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D350-636-011
Job Sheet 194935



Part No: D350-636-011

Job Qty: 1 pcs

Part Name: Skidtube LH, Std Wearplates, DART (Apical) Cylindrical/Aerazur Float Comp.



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 5/10/19

Job Tracking No:

Due Date: 5/31/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: D2750-041 REV:H IPP Rev:I 02.09.25 IPP Rev:J 06-03-23 As per Rev D IPP Rev:K 06-07.13 As per dsi9343
IPP Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM Verf:EC IPP Rev:M 08-04-22 DD verified:EC IPP
Rev:N 08-09-23 revF DD verified:ec IPP Rev:O 09-02-06 per PAR09-010 DD verf:EC IPP Rev:P 10.06.22
revise seq110 DD verf:EC IPP Rev:Q 10.10.01 as per IIN revH DDverf:EC IPP REV:R 13.08.27 PER ECN13-
594 DD VERF:JLM IPP REV:S 18.11.09 AS PER ECN18-830 DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup	Run	Workcenter / Supplier	Lead Time	
110	Skidtubes - 1	1 pcs	5/31/19		0.00	4.55	Skidtubes - 1		TE BE
							Skidtubes - 2		
							Skidtubes - 3		
							Skidtubes - 4		
							Skidtubes - 5		
							Skidtubes - 6		
							Skidtubes - 7		
120	QC 10	1 pcs	5/31/19		0.00	0.00	QC 10 - 10		MAY 27 2019
							QC 10 - 18		
							QC 10 - 24	DAS	
							QC 10 - 43	24	
							QC 10 - 50	9-89	
							QC 10 - 58		
							QC 10 - 9		
130	QC 5	1 pcs	5/31/19		0.00	0.00	QC 5 - 10		MAY 27 2019
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3	DAS	
							QC 5 - 43	24	
							QC 5 - 49	9-89	
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		

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140	Handfinish - 1-1 Chemical-B4B	1 pcs	5/31/19	0.00 0.93	QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
					Handfinish - 1 - 1 - B4B	
					Handfinish - 1 - 2 - B4B	20.9
					Handfinish - 1 - 3 - B4B	
					Handfinish - 1 - 4 - B4B	
					Handfinish - 1 - 5 - B4B	
					Handfinish - 1 - 6 - B4B	
					Handfinish - 1 - 7 - B4B	
					Handfinish - 1 - 8 - B4B	
					Handfinish - 1 - 9 - B4B	
					Handfinish - 1 - 10 - B4B	
					Handfinish - 1 - 11 - B4B	
					Handfinish - 1 - 12 - B4B	
					Handfinish - 1 - 13 - B4B	
					Handfinish - 1 - 14 - B4B	
					Handfinish - 1 - 15 - B4B	
					Handfinish - 1 - 16 - B4B	
					Handfinish - 1 - 17 - B4B	
					Handfinish - 1 - 18 - B4B	
					Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 - B4B	
					Handfinish - 1 - 21 - B4B	
					Handfinish - 1 - 22 - B4B	
150	QC 7	1 pcs	5/31/19	0.00 0.00	QC 7 - 10	
					QC 7 - 13	
					QC 7 - 14	
					QC 7 - 15	
					QC 7 - 17	
					QC 7 - 18	BE
					QC 7 - 19	
					QC 7 - 2	
					QC 7 - 28	
					QC 7 - 3	
					QC 7 - 30	
					QC 7 - 34	
					QC 7 - 36	
					QC 7 - 37	
					QC 7 - 41	
					QC 7 - 47	
					QC 7 - 48	
					QC 7 - 51	
					QC 7 - 58	
					QC 7 - 59	
					QC 7 - 60	
					QC 7 - 9	
					QC 7 - 68	

				QC 7 - 50	
				QC 7 - 67	
				QC 7 - 40	
				QC 7 - 24	
				QC 7 - 43	
160 Skidtubes - 2 - B4B	1 pcs	5/31/19	0.00 4.55	Skidtubes - 1 - B4B	DO
				Skidtubes - 2 - B4B	
				Skidtubes - 3 - B4B	
				Skidtubes - 4 - B4B	TE
				Skidtubes - 5 - B4B	BE
				Skidtubes - 6 - B4B	
				Skidtubes - 7 - B4B	
170 QC 10	1 pcs	5/31/19	0.00 0.00	QC 10 - 10	
				QC 10 - 18	
				QC 10 - 24	DAS
				QC 10 - 43	24
				QC 10 - 50	9-89
				QC 10 - 58	
				QC 10 - 9	
180 QC 5	1 pcs	5/31/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	DAS
				QC 5 - 43	24
				QC 5 - 49	9-89
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
190 Handfinish - 2-1 Pressure-B4B	1 pcs	5/31/19	0.00 0.93	Handfinish - 2 - 1 - B4B	
				Handfinish - 2 - 2 - B4B	
				Handfinish - 2 - 3 - B4B	
				Handfinish - 2 - 4 - B4B	
200 Spray Paint - 2 - B4B	1 pcs	5/31/19	0.00 0.91	Spray Paint - 1 - B4B	RD 19-6-14
				Spray Paint - 2 - B4B	
				Spray Paint - 3 - B4B	
				Spray Paint - 4 - B4B	
205 Outsource - 11 - Paint	1 pcs	5/31/19		ATE003-VC	5
210 QC 14	1 pcs	5/31/19	0.00 0.00	QC 14 - 15	
				QC 14 - 2	
				QC 14 - 34	
				QC 14 - 41	
				QC 14 - 51	
				QC 14 - 58	
				QC 14 - 59	
				QC 14 - 9	
				QC 14 - 68	
				QC 14 - 40	
				QC 14 - 19	
				QC 14 - 43	
				QC 14 - 24	

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230 Handfinish - 4-1-Assembly-B4B	1 pcs	5/31/19	0.00 0.93	Handfinish - 4 - 1 - B4B	
				Handfinish - 4 - 10 - B4B	BEB 19-06-18
				Handfinish - 4 - 11 - B4B	
				Handfinish - 4 - 12 - B4B	
				Handfinish - 4 - 13 - B4B	
				Handfinish - 4 - 14 - B4B	
				Handfinish - 4 - 15 - B4B	
				Handfinish - 4 - 2 - B4B	
				Handfinish - 4 - 3 - B4B	
				Handfinish - 4 - 4 - B4B	
				Handfinish - 4 - 5 - B4B	
				Handfinish - 4 - 6 - B4B	
				Handfinish - 4 - 7 - B4B	
				Handfinish - 4 - 8 - B4B	
				Handfinish - 4 - 9 - B4B	
240 QC 5	1 pcs	5/31/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	JUN 21 2019 DAS 68
				QC 5 - 9	9-89
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
250 Packaging 1-1 - Pick Kit - B4B	1 pcs	5/31/19	0.00 0.00	Packaging 1 - 1 - B4B	
				Packaging 1 - 2 - B4B	
				Packaging 1 - 3 - B4B	
				Packaging 1 - 4 - B4B	
				Packaging 1 - 5 - B4B	DAS
				Packaging 1 - 6 - B4B	28
				Packaging 1 - 7 - B4B	9-89
				Packaging 1 - 8 - B4B	
				Packaging 1 - 9 - B4B	
				Packaging 1 - 10 - B4B	
				Packaging 1 - 11 - B4B	
				Packaging 1 - 12 - B4B	
				Packaging 1 - 13 - B4B	
				Packaging 1 - 14 - B4B	
				Packaging 1 - 15 - B4B	
				Packaging 1 - 16 - B4B	
				Packaging 1 - 17 - B4B	
				Packaging 1 - 18 - B4B	
				Packaging 1 - 19 - B4B	
				Packaging 1 - 20 - B4B	
				Packaging 1 - 21 - B4B	
				Packaging 1 - 22 - B4B	

				Packaging 1 - 23 - B4B	
				Packaging 1 - 24 - B4B	
				Packaging 1 - 25 - B4B	
				Packaging 1 - 26 - B4B	
				Packaging 1 - 27 - B4B	
				Packaging 1 - 28 - B4B	
				Packaging 1 - 29 - B4B	
				Packaging 1 - 30 - B4B	
				Packaging 1 - 31 - B4B	
				Packaging 1 - 32 - B4B	
				Packaging 1 - 33 - B4B	
				Packaging 1 - 34 - B4B	
				Packaging 1 - 35 - B4B	
				Packaging 1 - 36 - B4B	
260 QC 4	1 pcs	5/31/19	0.00 0.00	QC 4 - 28	
				QC 4 - 58	
				QC 4 - 69	DAS
				QC 4 - 9	75 JUL 10 2019
				QC 4 - 46	9-89
				QC 4 - 68	
				QC 4 - 72	
270 Packaging 3-1 - Stock - B4B	1 pcs	5/31/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	DAS
				Packaging 3 - 9 - B4B	75 JUL 10 2019
				Packaging 3 - 10 - B4B	9-89
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
275 DC - 1 - B4B	1 pcs	5/31/19	0.00 0.00	DC - 1 - B4B	DAS
				DC - 2 - B4B	21 JUL 10 2019

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280 QC 21 - FG

1

5/31/19

0.00 0.00

QC 21 - FG - 21

QC 21 - FG - 70

QC 21 - SA - 53

pcs

- Part Op 110 - (Skid tubes) 1- Pick D2600-3 Bent 2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside AFT
- Descriptions: end per dwg D2750-1 3- Drill pilot holes for blade fitting bolt holes using DT8983. Start with 3/16", then open to 0.500" using center drill then ream holes using 0.500" reamer. PIN first side. Repeat process on second side. ***ENSURE PROPER POSITIONING FWD BEND MUST BE FACING UP WHEN DRILLING FIRST SIDE*** Drill pilot holes as per Dwg D2750 sheet 4 (D2750-1 details). Drill using drill Jig DT8150 & DT8863A for 2nd side only DT8863B for first side (detail B) 4- Locate DT8330 off of blade fitting bolt holes and drill pilot holes for blade fitting. Open to 0.500" using hole saw. VERIFY AND RECORD FWD BEND ANGLE. 5- Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to 0.297". 6- Open up holes of Detail A to 0.297" (total of 2 holes per side) 7- Weld D2744 Cap as per Dwg D2750 and QSI 004. Fill grooves in bend left from bending as per QSI 004 A/R Aluminum Rod batch: 138987 8- Grind welds flush as per Dwg D2750
- 120 - (QC10- Inspect visual per QSI004- ground welds)
- 130 - (QC5- Inspect part completeness to step on W/O)
- 140 - (Chemical Conversion Coat per QSI005 4.1)
- 150 - (QC7- Inspect Chemical Conversion Coat)
- 160 - (Skid tubes) 1- Open up holes using hole saw of Detail C and ground handling to 0.625" (total of 8 holes per side) as per dwg D2750. 2- Open up holes using hole saw of Detail B to 0.750" (total of 4 holes per side) as per dwg D2750. 3- Open float hole using un-bit to 0.500" (4 per side) 4- Chamfer holes of Detail B, C, ground handling and float holes per dwg D2750 (welding instructions on sheet 8) 5- Deburr and blow out all chips from inside of tube 6- Prepare tube for welding, remove alodine as required. 7- Bond web D2739 in place as per QSI 015, let cure for 12hrs. A/R Sikaflex-291 batch: 5163437 exp. date 07/2019 ***ATTN: USE I-BEAM LOCATION AID (BLADE FITTING)*** 8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004 (welding instructions on sheet 8) A/R Aluminum Rod batch: 139017 9- At section AJ-AJ drill out x-bolt spacer to 0.404" 10- Grind welds flush as per Dwg D2750 11- Spot face ground handling holes section (total of 4 places per side) as per dwg D2750 12- Deburr holes, ensure tube is free of all scratches before sending to paint.
- 170 - (QC10- Inspect visual per QSI004- ground welds)
- 180 - (QC5- Inspect part completeness to step on W/O) ***VERIFY C'BOARD IS GOOD***
- 190 - (Pressure Wash per QSI005 4.3/ Clean and remove all markings) Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.
- 200 - (Spray Paint / NDT Room) 1- PRIME AS PER DWG AND QSI 005 4.2 PRIMER PRC DESOTO 515X349 BATCH: 5189840 2- PAINT WHITE AS PER DWG AND QSI 005 4.2 PAINT BATCH: 5144715
- 205 - (Consignment Stock)
- 210 - (QC14- Inspect Spray Paint) Inspect for foreign object per QSI 024
- 230 - (Assemble as per dwg) 1- Install inserts as per Dwg D2750 2- Inspect for Foreign Objects 3- Install blade fitting D3488-041, wearshoes and ground handling hardware as per dwg D2750 SIKAFLEX 241 BATCH: 5163437 EXP DATE: 19/12 4- Assemble o-ring to plug as per dwg D3492 and apply o-ring lube A/R 55-o-ring lube batch: M138843 5- Coat all exposed fasteners with "LPS Procyon" batch: M133690
- 240 - (QC5- Inspect part completeness to step on W/O)
- 250 - (Pick Kit)
- 260 - (QC4- 100% Inspect kits for completeness) *****ensure antiseize is on AN8C21A bolts*****
- 270 - (Identify as per dwg & Stock Location: FL108 Package as per PPP D350-636-011 Location : FG108
- 275 - (Document Control) record fwd angle: _____ Photocopy blue file and type labels per PPP D350-636-011
- CHG 008
- 280 - (QC21- Final Inspection - Work Order Release)

Job BOM

M.U. 010424

Part / Item	Component Name	Quantity	Operation	Container
D2600-3-BENT-LH	Extrusion Bent LH	1 pcs (1 ea)	110-Skiddtubes - 1	5182077
D2744	Cap	1 pcs (1 ea)	110-Skiddtubes - 1	5150291
D2739	350 I-Beam	1 pcs (1 ea)	160-Skiddtubes - 2 - B4B	5180535
D2743	Crossbolt Spacer	8 pcs (8 ea)	160-Skiddtubes - 2 - B4B	5182366
D3490-1	Cross Bolt Spacer	4 pcs (4 ea)	160-Skiddtubes - 2 - B4B	5160920 *2 5186298 *2
D3490-3	Cross Bolt Spacer	4 pcs (4 ea)	160-Skiddtubes - 2 - B4B	5171591
AN3C5A	Bolt	34 Ea (34 ea)	230-Handfinish - 4-1-Assembly-B4B	5176455
AN3C6A	Bolt	4 Ea (4 ea)	230-Handfinish - 4-1-Assembly-B4B	5174235
AN6C44A	Bolt	4 Ea (4 ea)	230-Handfinish - 4-1-Assembly-B4B	5176396
AN8C35A	Bolt	1 Ea (1 ea)	230-Handfinish - 4-1-Assembly-B4B	5167090
D2745	Bushing	8 pcs (8 ea)	230-Handfinish - 4-1-Assembly-B4B	5188184
D3488-3	Blade Fitting, LH	1 pcs (1 ea)	230-Handfinish - 4-1-Assembly-B4B	5179198
D3492-1	Plug	8 pcs (8 ea)	230-Handfinish - 4-1-Assembly-B4B	5183175
D3492-3	Plug	8 pcs (8 ea)	230-Handfinish - 4-1-Assembly-B4B	5163290
D3537-1	Wearpad	3 pcs (3 ea)	230-Handfinish - 4-1-Assembly-B4B	5181203
D3631-1	Washer	8 pcs (8 ea)	230-Handfinish - 4-1-Assembly-B4B	5184192
D3791-1	Wearpad	1 pcs (1 ea)	230-Handfinish - 4-1-Assembly-B4B	5180555
D3793-1	Wearplate Fwd	1 pcs (1 ea)	230-Handfinish - 4-1-Assembly-B4B	5176769
D3793-3	Wearplate Aft	1 pcs (1 ea)	230-Handfinish - 4-1-Assembly-B4B	5187517
MS21043-6	Nut	4 Ea (4 ea)	230-Handfinish - 4-1-Assembly-B4B	5181777
MS21083C8	Nut	1 Ea (1 ea)	230-Handfinish - 4-1-Assembly-B4B	5167203-1
NAS1149C0332R	Washer	38 Ea (38 ea)	230-Handfinish - 4-1-Assembly-B4B	5158078
NAS1149C0832R	Washer	1 Ea (1 ea)	230-Handfinish - 4-1-Assembly-B4B	5076017-2
NAS1515H3L	Washer	4 Ea (4 ea)	230-Handfinish - 4-1-Assembly-B4B	5083559
NAS1611-010	O-Ring	8 Ea (8 ea)	230-Handfinish - 4-1-Assembly-B4B	5092499
NAS1611-013	O-Ring	8 Ea (8 ea)	230-Handfinish - 4-1-Assembly-B4B	5170279
ALS4-1032-225	Rivnut	38 Ea (38 ea)	230-Handfinish - 4-1-Assembly-B4B	5167517
D3793-5	Wearpad	1 pcs (1 ea)	230-Handfinish - 4-1-Assembly-B4B	5189165
AN8C21A	Bolt	2 Ea (2 ea)	250-Packaging 1-1 - Pick Kit - B4B	5160967
D2741	Replacement Blade	1 pcs (1 ea)	250-Packaging 1-1 - Pick Kit - B4B	5159549
D3493-1	Washer	2 pcs (2 ea)	250-Packaging 1-1 - Pick Kit - B4B	5171348
D3532-1	Spacer	2 pcs (2 ea)	250-Packaging 1-1 - Pick Kit - B4B	5163195
MS21083C8	Nut	2 Ea (2 ea)	250-Packaging 1-1 - Pick Kit - B4B	5167203
NAS1149D0863J	Washer	2 Ea (2 ea)	250-Packaging 1-1 - Pick Kit - B4B	5166718

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Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
110-Skidtubes - 1	D2600-3-BENT-LH	1	1	0
	D2744	1	11	0
160-Skidtubes - 2 - B4B	D2739	1	8	0
	D2743	8	55	0
	D3490-1	4	18	0
	D3490-3	4	30	0
	ALS4-1032-225	38	1,583	0
230-Handfinish - 4-1-Assembly-B4B	AN3C5A	34	1,743	0
	AN3C6A	4	289	0
	AN6C44A	4	179	0
	AN8C35A	1	55	0
	D2745	8	112	0
	D3488-3	1	16	0
	D3492-1	8	45	0
	D3492-3	8	147	0
	D3537-1	3	36	0
	D3631-1	8	141	0
	D3791-1	1	1	0
	D3793-1	1	19	0
	D3793-3	1	13	0
	D3793-5	1	13	0
	MS21043-6	4	149	0
	MS21083C8	1	193	0
	NAS1149C0332R	38	5,129	0
	NAS1149C0832R	1	333	0
	NAS1515H3L	4	330	0
	NAS1611-010	8	343	0
	NAS1611-013	8	248	0
250-Packaging 1-1 - Pick Kit - B4B	AN8C21A	2	95	0
	D2741	1	58	0
	D3493-1	2	49	0
	D3532-1	2	69	0
	MS21083C8	2	193	0
	NAS1149D0863J	2	455	0
Part Specifications				
Specifications could not be found.				

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QTY -041	QTY -042	QTY -043	QTY -044	QTY -051	QTY -052	P/N	DESCRIPTION
X						D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X					D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X				D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X			D2750-044	350 SKIDTUBE ASSEMBLY, RH
				X		D2750-051	350 SKIDTUBE ASSEMBLY, LH
					X	D2750-052	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	1	1	D2739	WEB
8	8	8	8	8	8	D2743	CROSS BOLT SPACER
1	1	1	1	1	1	D2744	CAP
8	8	8	8	8	8	D2745	BUSHING
1						D2750-1	350 SKIDTUBE ASSEMBLY
	1					D2750-2	350 SKIDTUBE ASSEMBLY
		1				D2750-3	350 SKIDTUBE ASSEMBLY
			1			D2750-4	350 SKIDTUBE ASSEMBLY
				1		D2750-5	350 SKIDTUBE ASSEMBLY
					1	D2750-6	350 SKIDTUBE ASSEMBLY
1		1		1		D3488-3	BLADE FITTING, LH
	1		1		1	D3488-4	BLADE FITTING, RH
4	4	4	4			D3490-1	CROSS BOLT SPACER
4	4					D3490-3	CROSS BOLT SPACER
		4	4			D3490-5	CROSS BOLT SPACER
8	8	8	8			D3492-041	PLUG
8	8					D3492-043	PLUG
		8	8			D3492-045	PLUG
3	3	3	3	3	3	D3537-1	WEARPAD
8	8	8	8	8	8	D3631-1	WASHER
1	1	1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	1	1	D3793-5	WEARSHOE
38	38	38	38	38	38	ALS4-1032-225	INSERT
				1	1	AN3C34A	BOLT
34	34	34	34	34	34	AN3C5A	BOLT
4	4	4	4	4	4	AN3C6A	BOLT
4	4	4	4	4	4	AN6C44A	BOLT
1	1	1	1	1	1	AN8C35A	BOLT
				1	1	MS21043-3	NUT
4	4	4	4	4	4	MS21043-6	NUT
1	1	1	1	1	1	MS21083C8	NUT
38	38	38	38	38	38	NAS1149C0332R	WASHER
				2	2	NAS1149C0363R	WASHER
1	1	1	1	1	1	NAS1149C0832R	WASHER
4	4	4	4	4	4	NAS1515H3L	WASHER

NOTES:

- 1) MATERIAL: MAKE D2750-1/-2/-3/-4/-5/-6 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- 2) FINISH: ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB. STANDARD: PRIME (REF. 4.2.1.3.3) AND PAINT WHITE PER DART QSI 005 4.2. OPTIONAL: POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3. BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D2750-041/-042/-043/-044 = 26.1 lbs
D2750-051/-052 = 25.7 lbs
- 8) WELD PER DART QSI 004
- 9) INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 19/64" SIZE HOLES ($\phi 0.297$) FOR WEARSHOE INSERTS
- 10) FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 KSI
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- 11) COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF FINISH WITH MEK DEGREASER.
- 12) SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- 13) SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

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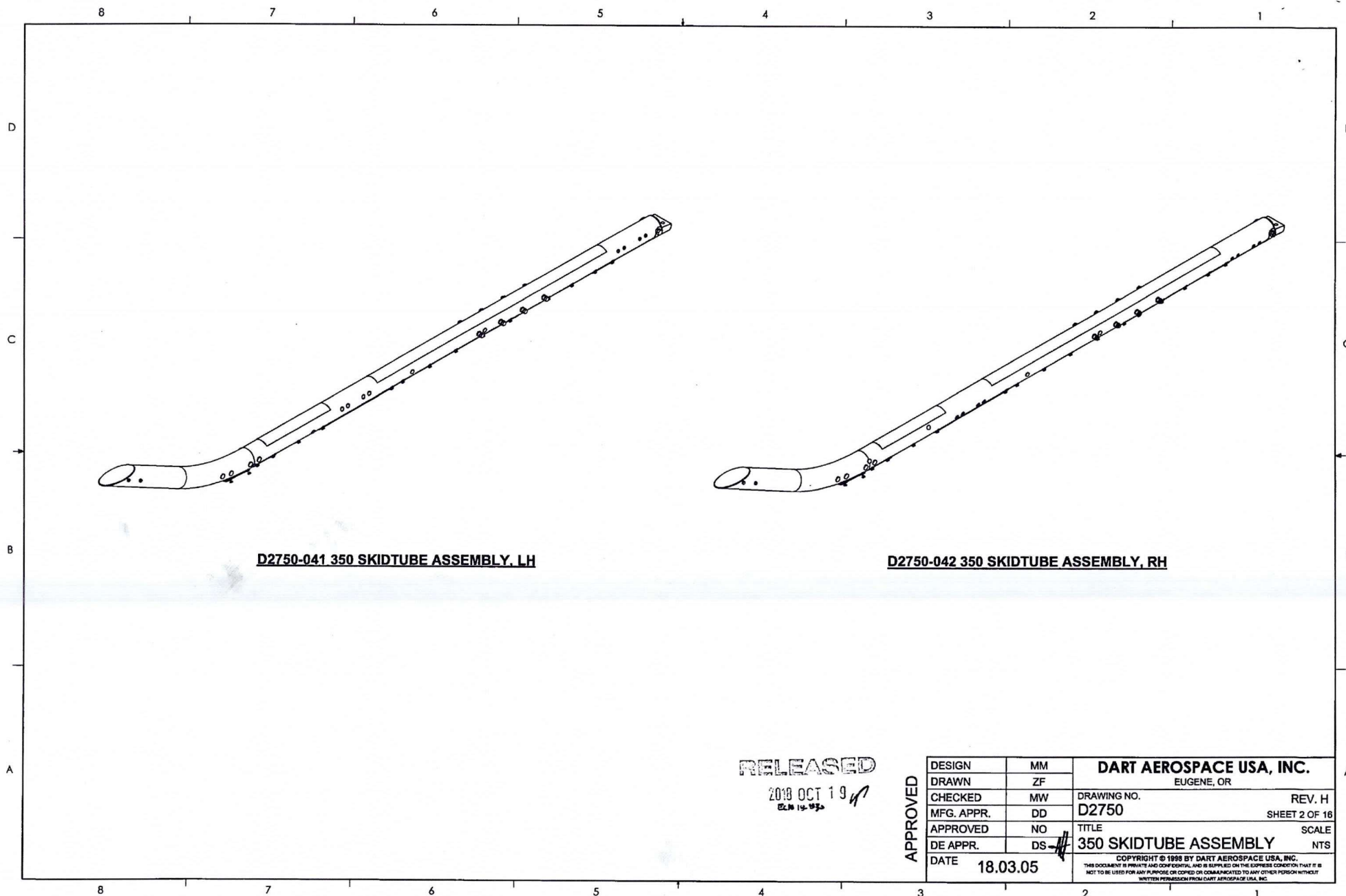
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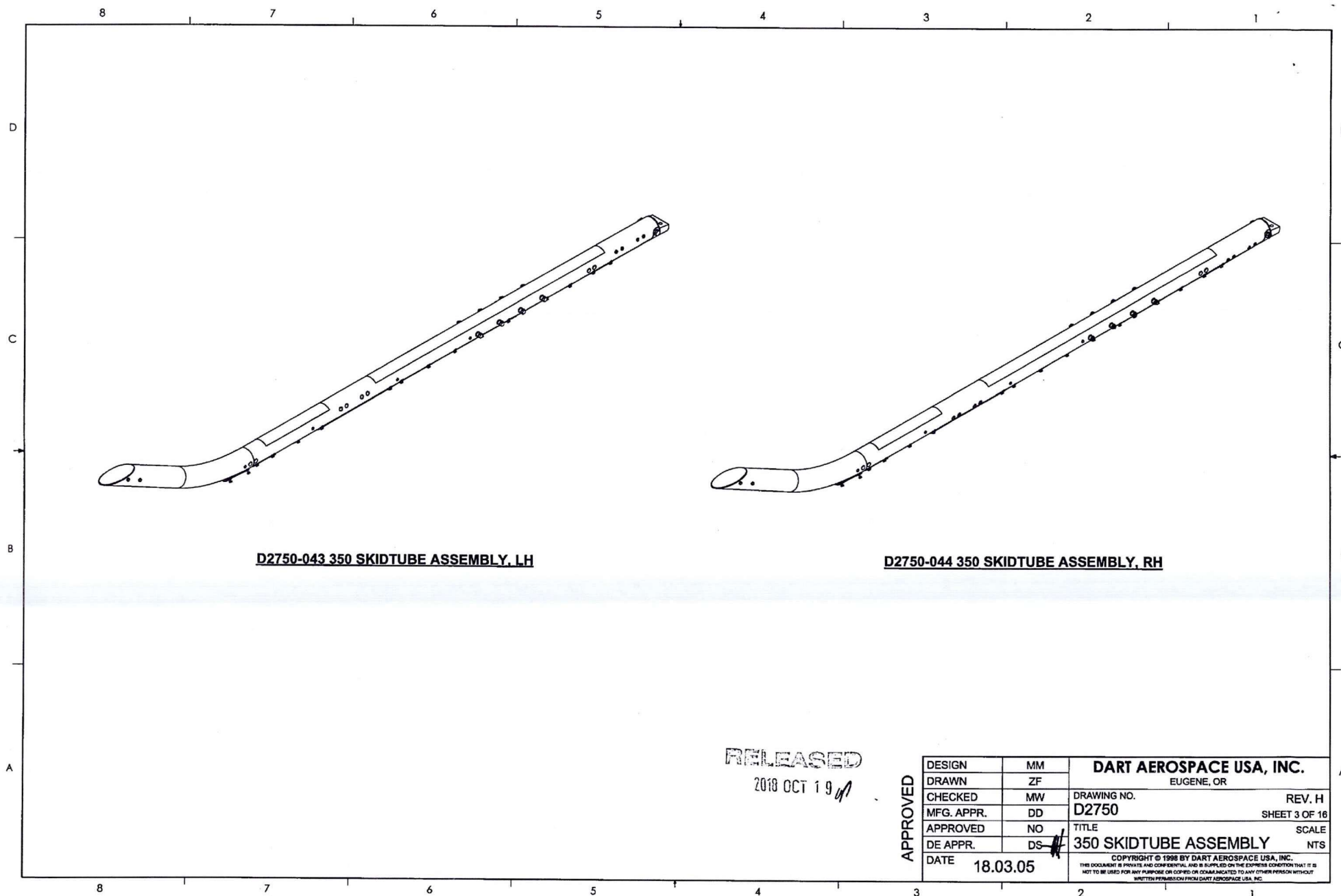
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H	ADDED -051/-052 (ZN D5-1 SHEETS 4, 15-18); ADDED D2750-5/-6 (ZN C5-1 SHEETS 9, 10); D3488-3/-4 REPLACES D3488-041/-042 (ZN C5-1, D2-11/-12/-13/-14); D3793-5 REPLACES D3535-25 (ZN B6-1, C4-11/-12/-13/-14); NAS1149C0332R REPLACES AN860C10L (ZN A5-1, B1-11/-12/-13/-14, C7-11/-12/-13/-14); NAS1149C0832R REPLACES AN960C816L (ZN A5-1, C1-11/-12/-13/-14); REMOVED D3794-1/-3, AND D3536-25 GASKETS	ZF	18.03.05
G	CORRECTED TOLERANCE ON $\phi 0.500$ THRU HOLE: IS +0.01/-0.000, WAS +0.100/-0.000 (ZN B3-4, B2-5); ADD VIEW TO CONTROL FWD BEND ORIENTATION (ZN D-14/-5/-6/-7); UPDATED FINISH OPTIONS; INSIDE OF TUBE NO LONGER SPRAYED WITH LPS-3. REASON: PAR13-276 AND NCR13-2757	MB	13.07.11
F	INCORPORATE DSI 9413; QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/-3 REPLACES D3535-13/-35 (ZN C8-1); D3794-1/-3 REPLACES D3536-13/-35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL); WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS; CHANGE INSERTS; ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H8L; REMOVE D2741; QTY (2) AN860C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEO 9133/9157	PH	08.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24894-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
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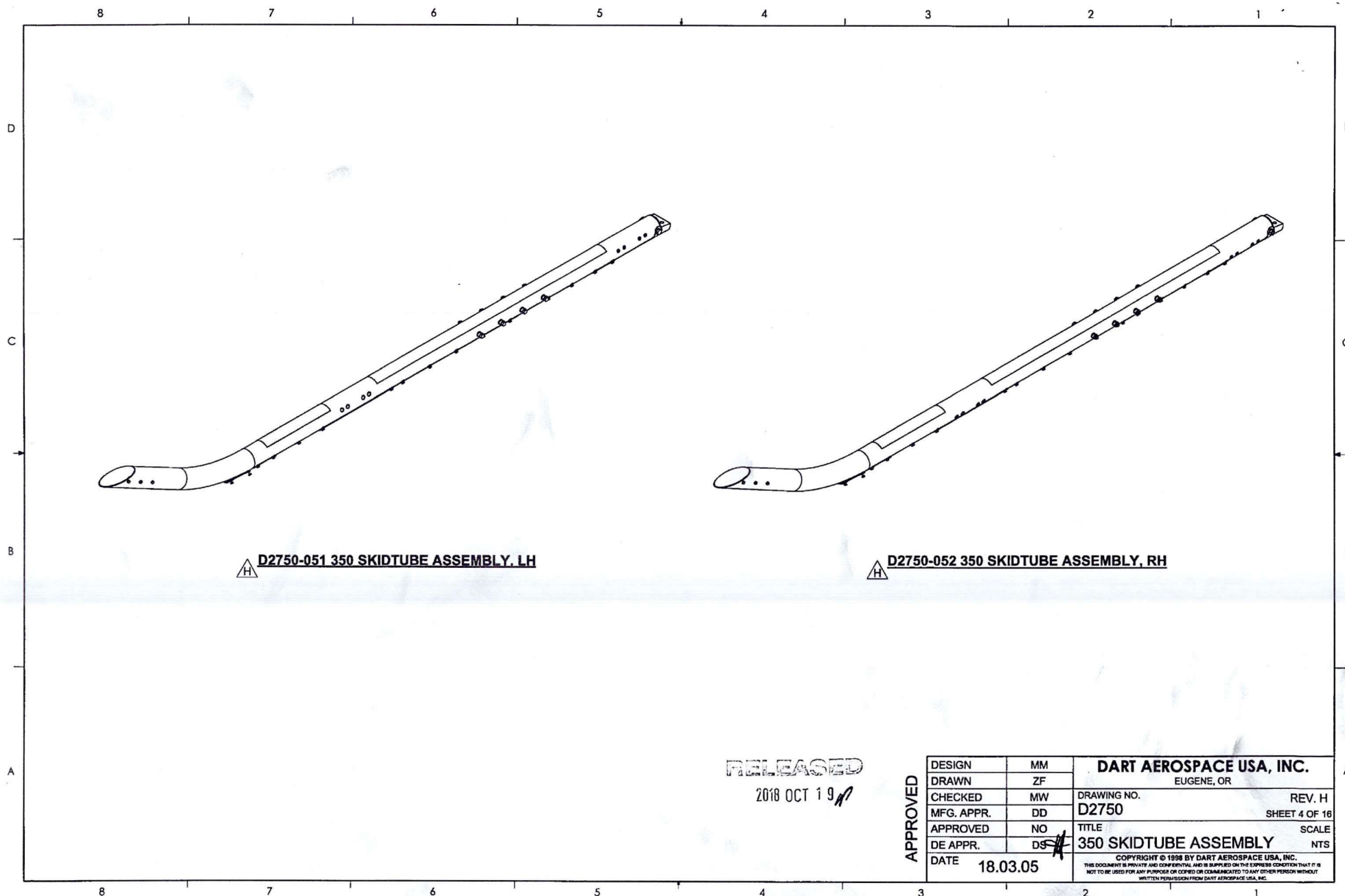
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D2750-044 350 SKIDTUBE ASSEMBLY, RH

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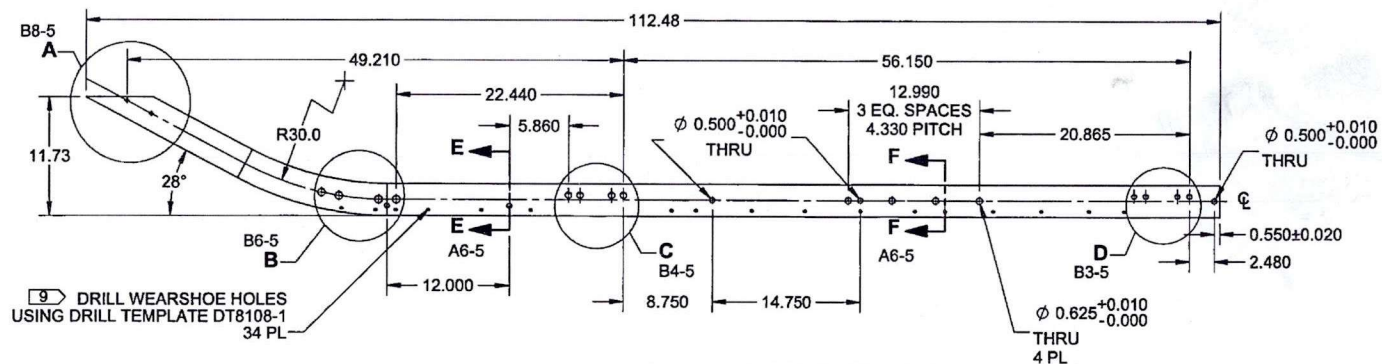
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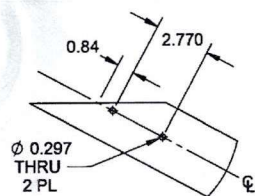
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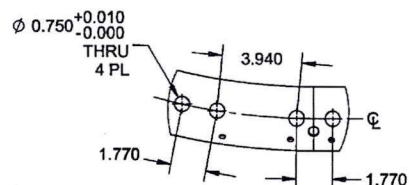
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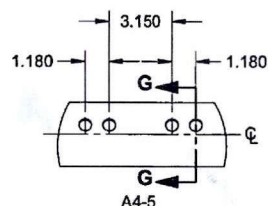
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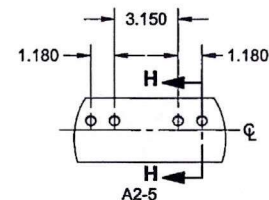
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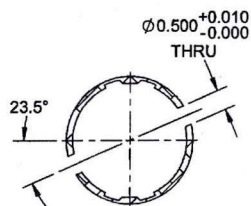
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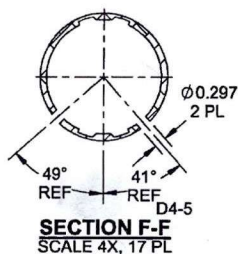
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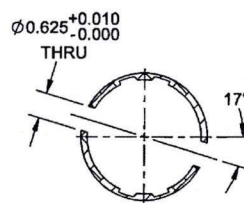
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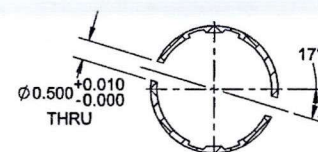
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D4-5
SECTION F-F
SCALE 4X, 17 PL



B4-5
SECTION G-G
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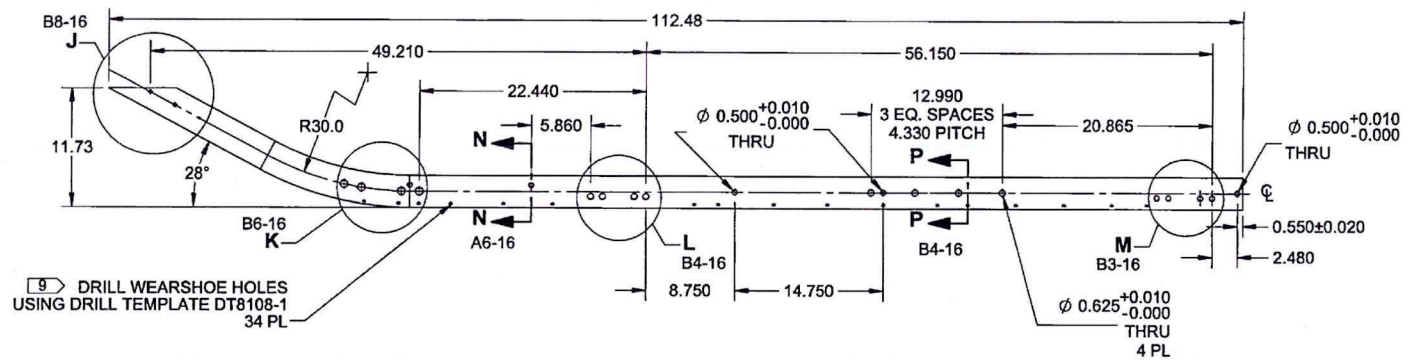


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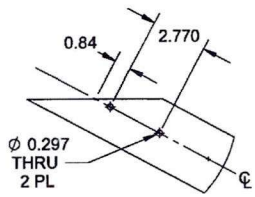
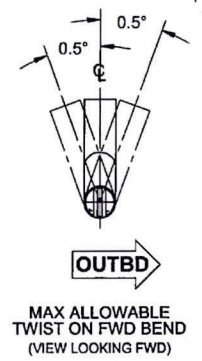
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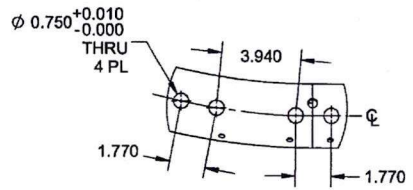
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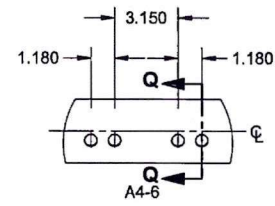
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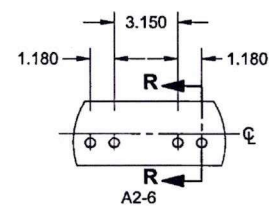
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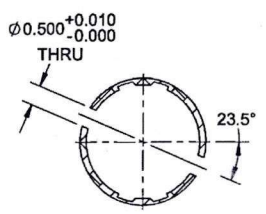
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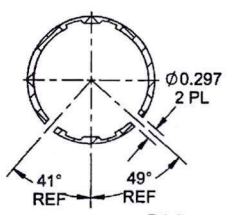
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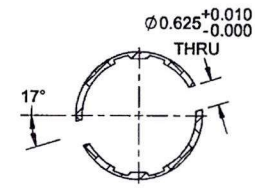
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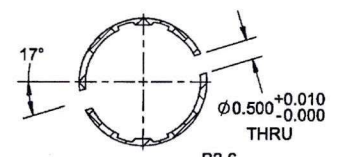
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SECTION P-P
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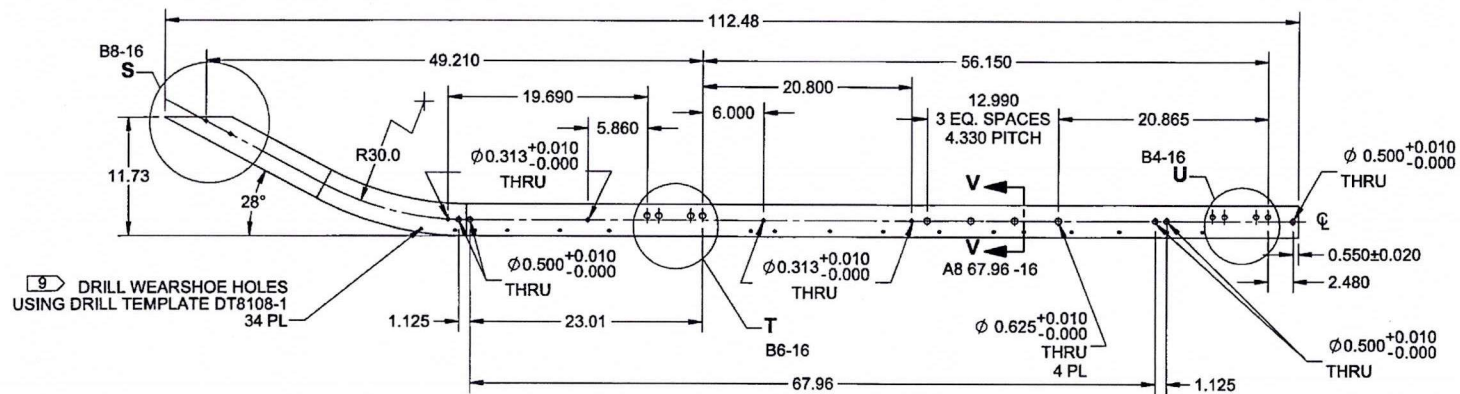
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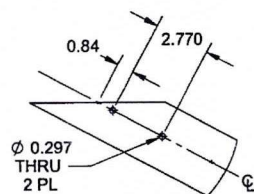
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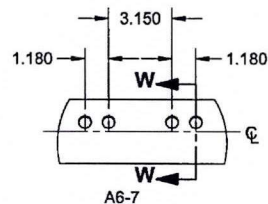
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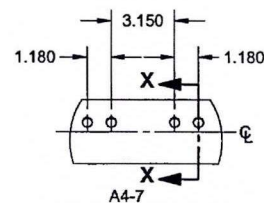
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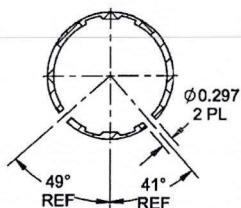
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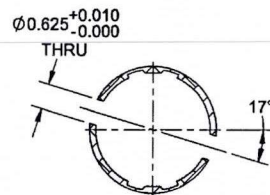
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DETAIL T
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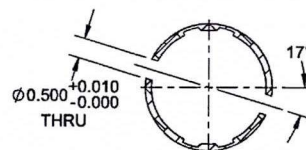
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DETAIL U
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D4-7
SECTION V-V
SCALE 4X, 17 PL



B6-7
SECTION W-W
SCALE 4X, 4 PL

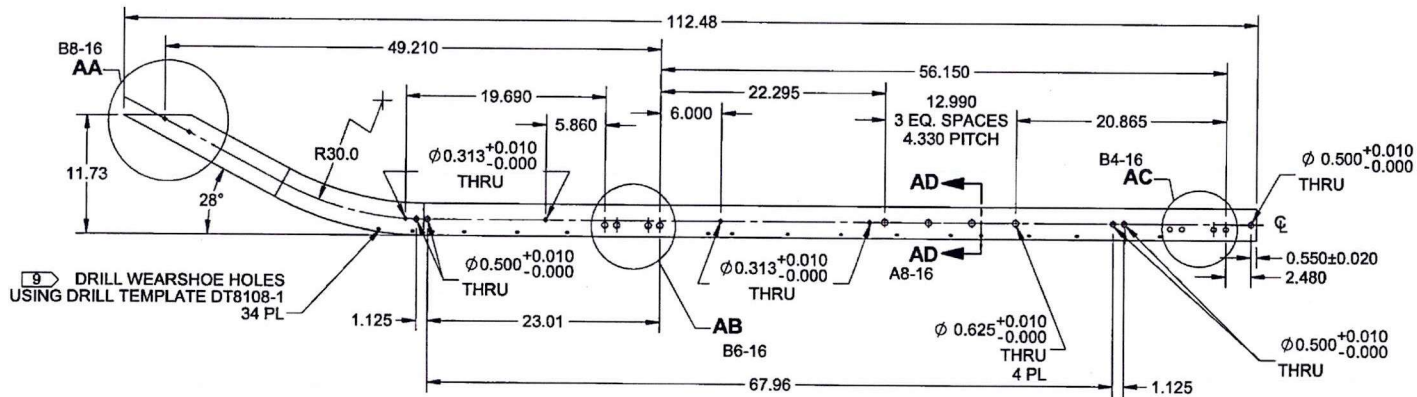


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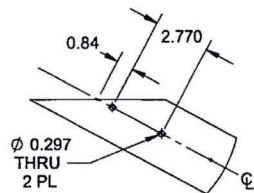
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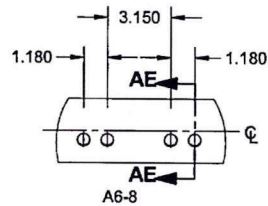
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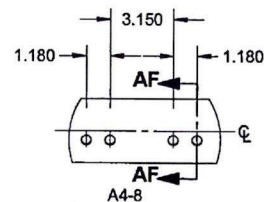
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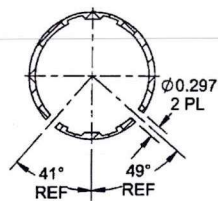
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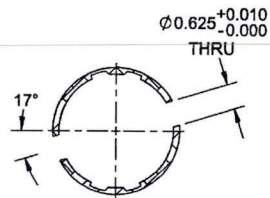
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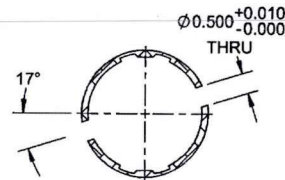
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SECTION AD-AD
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SECTION AE-AE
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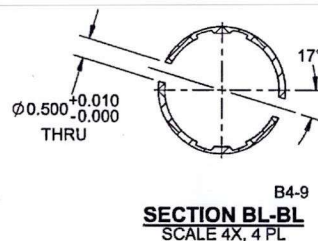
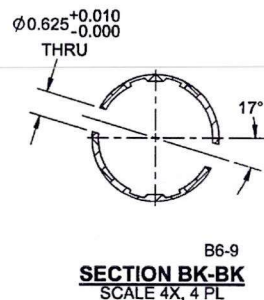
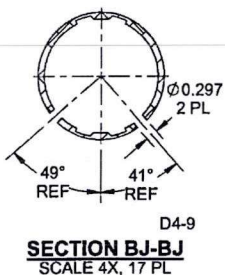
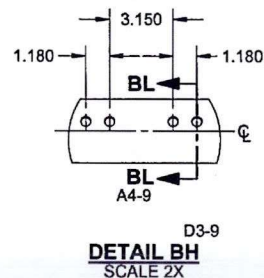
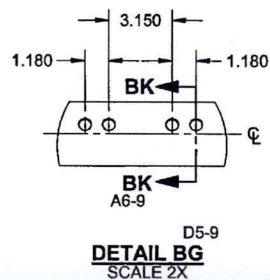
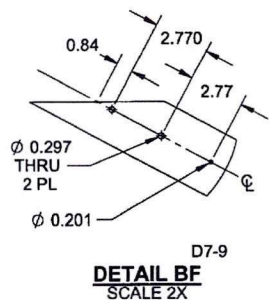
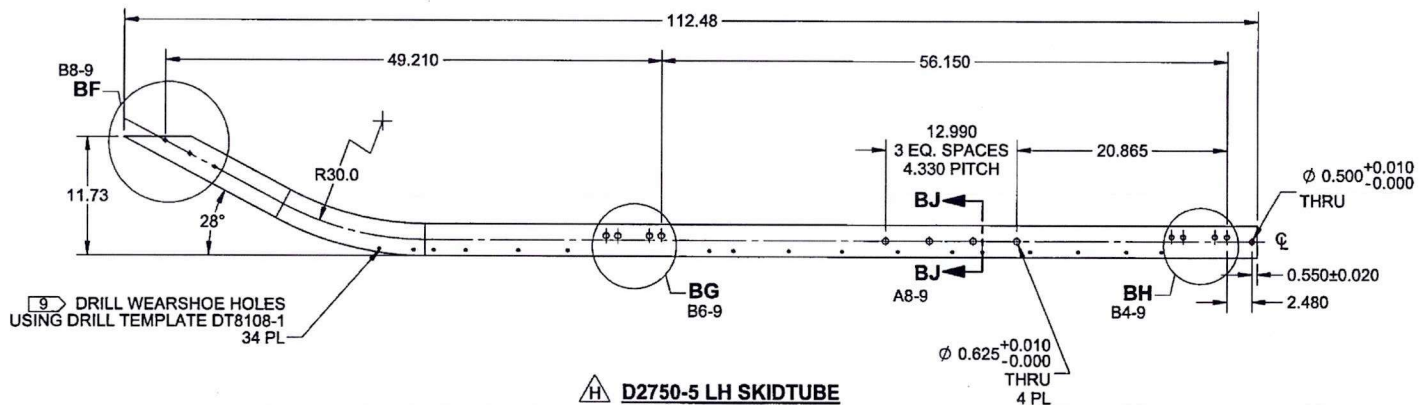
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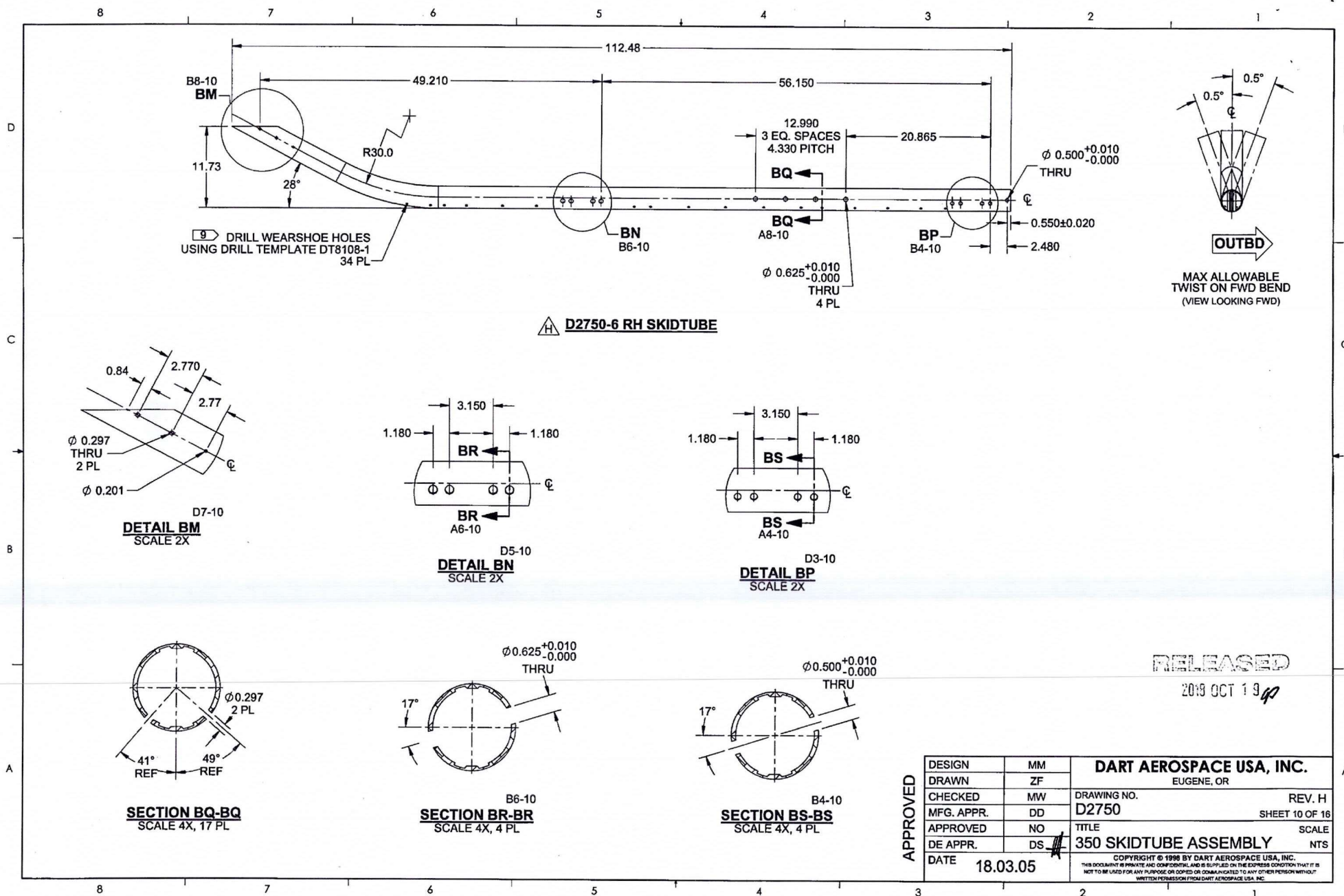
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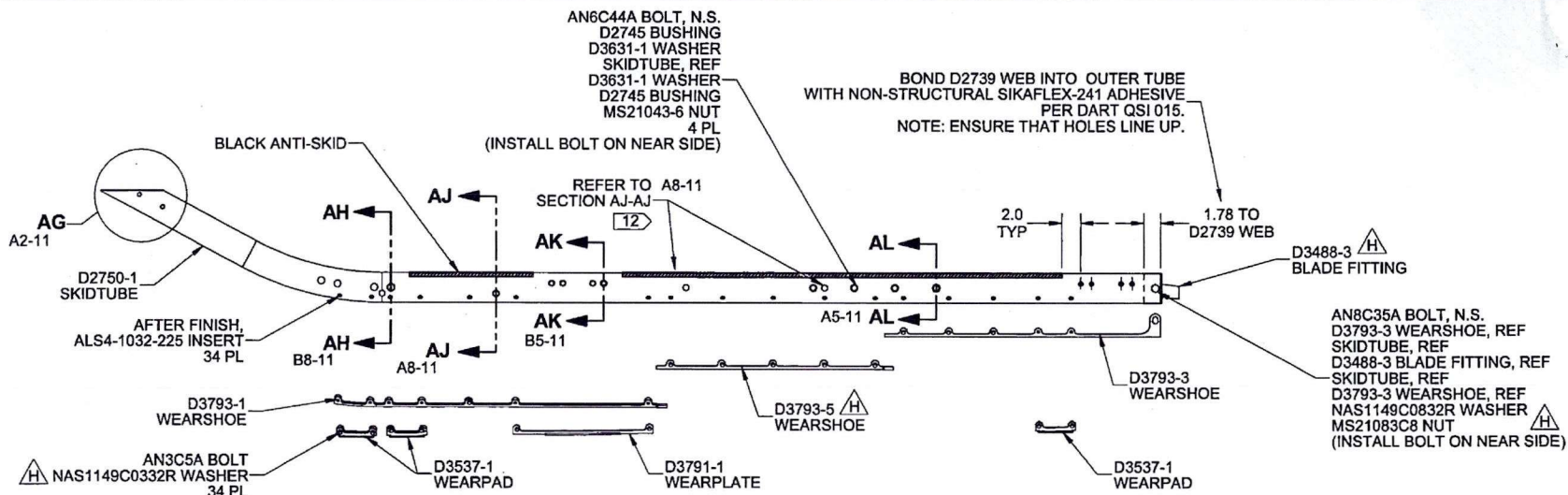


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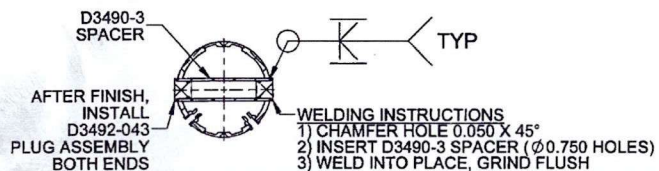
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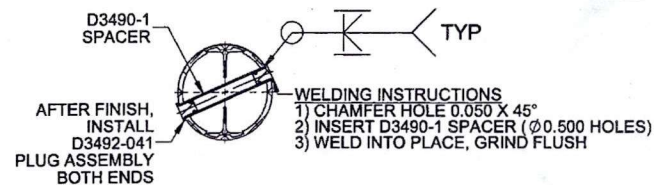
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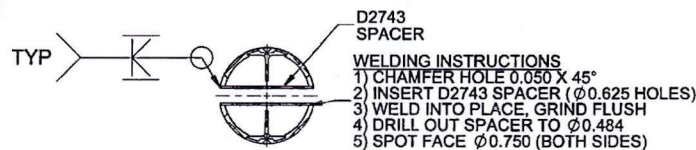
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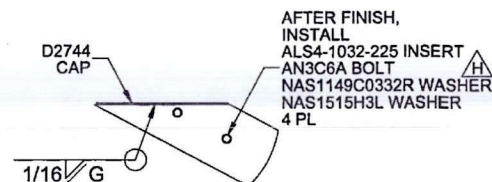
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SCALE 3X, 4 PL



SECTION AJ-AJ
SCALE 3X, 4 PL



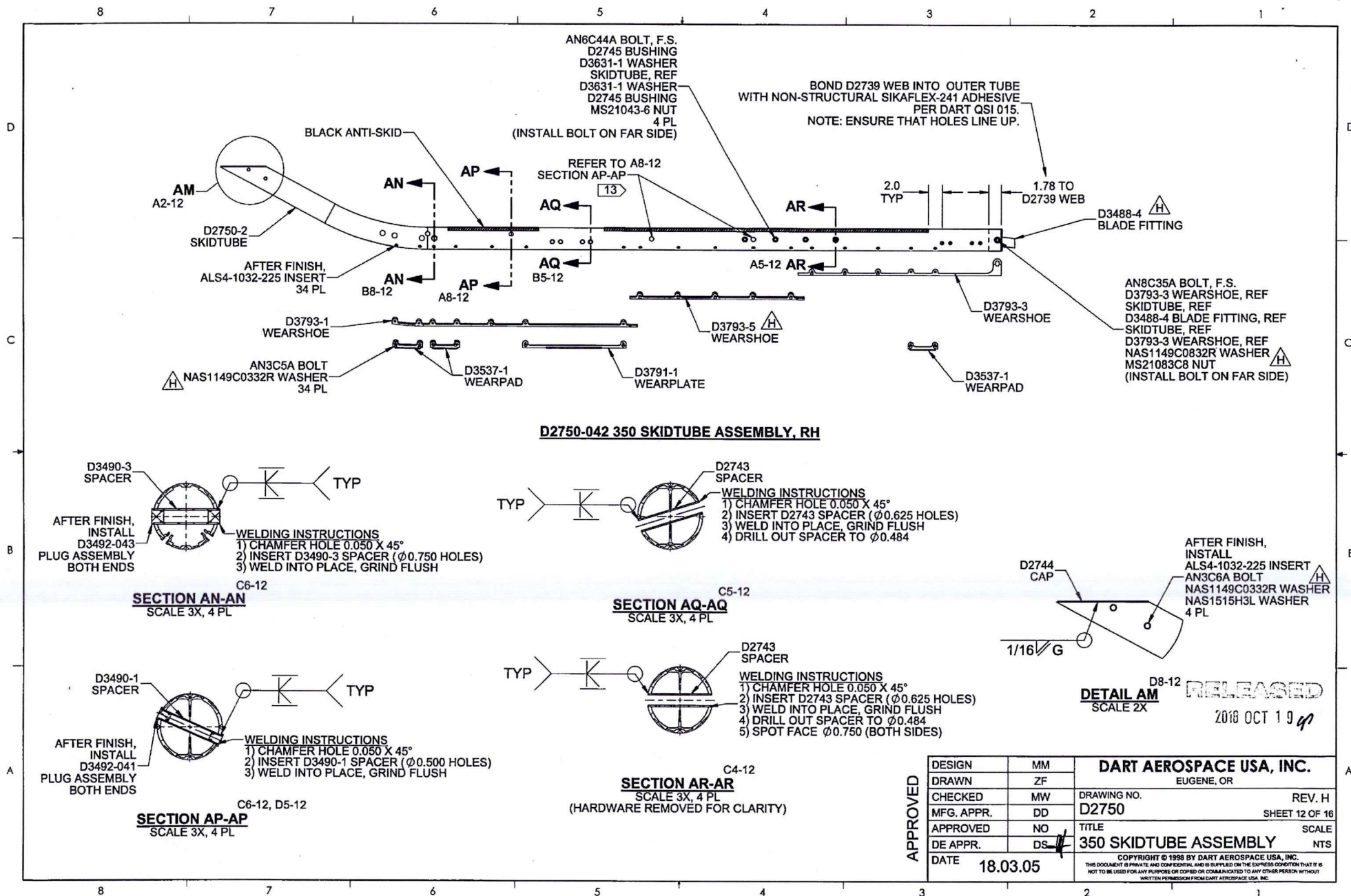
SECTION AL-AL
SCALE 3X, 4 PL
(HARDWARE REMOVED FOR CLARITY)

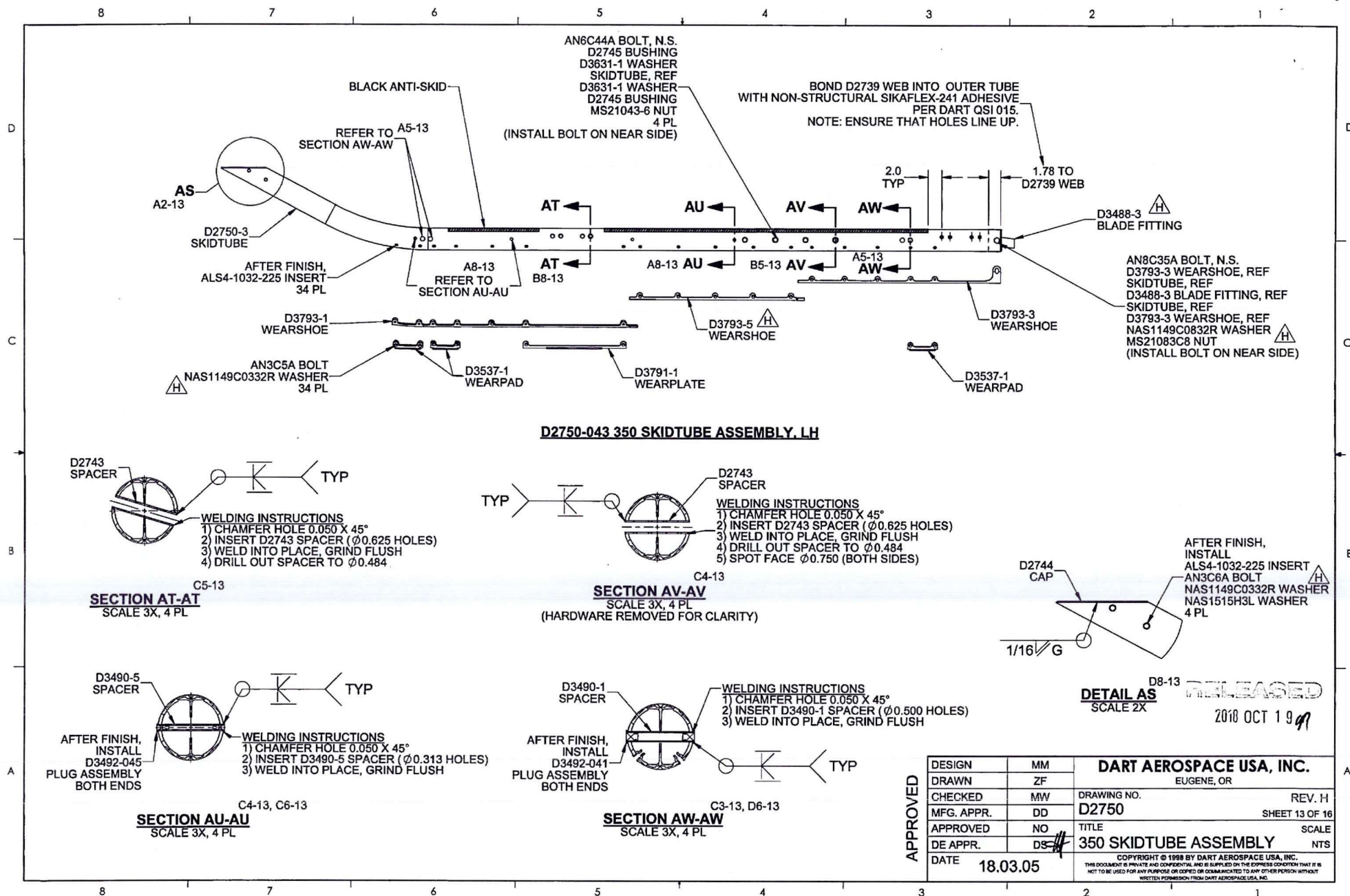


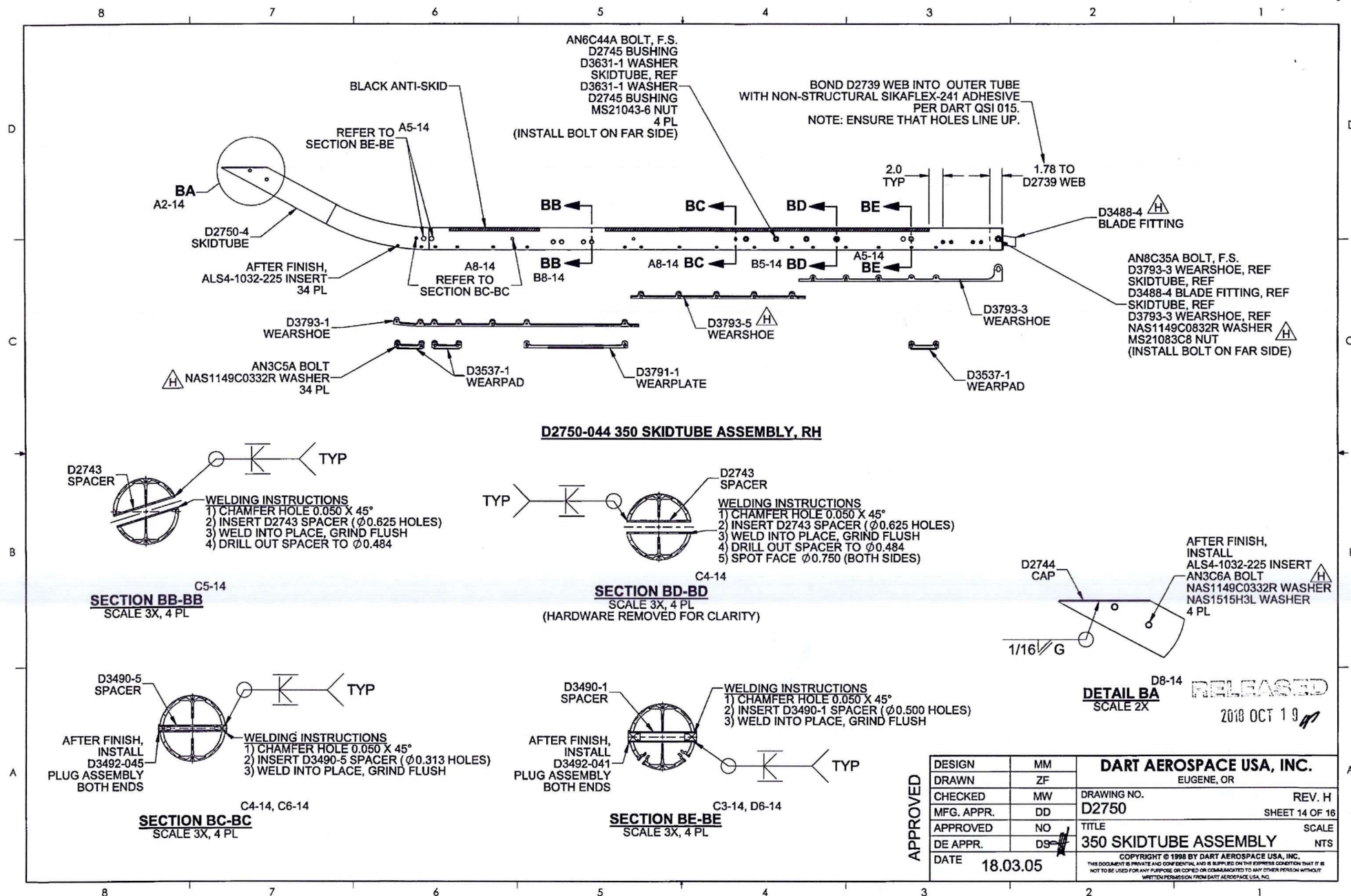
DETAIL AG
SCALE 2X

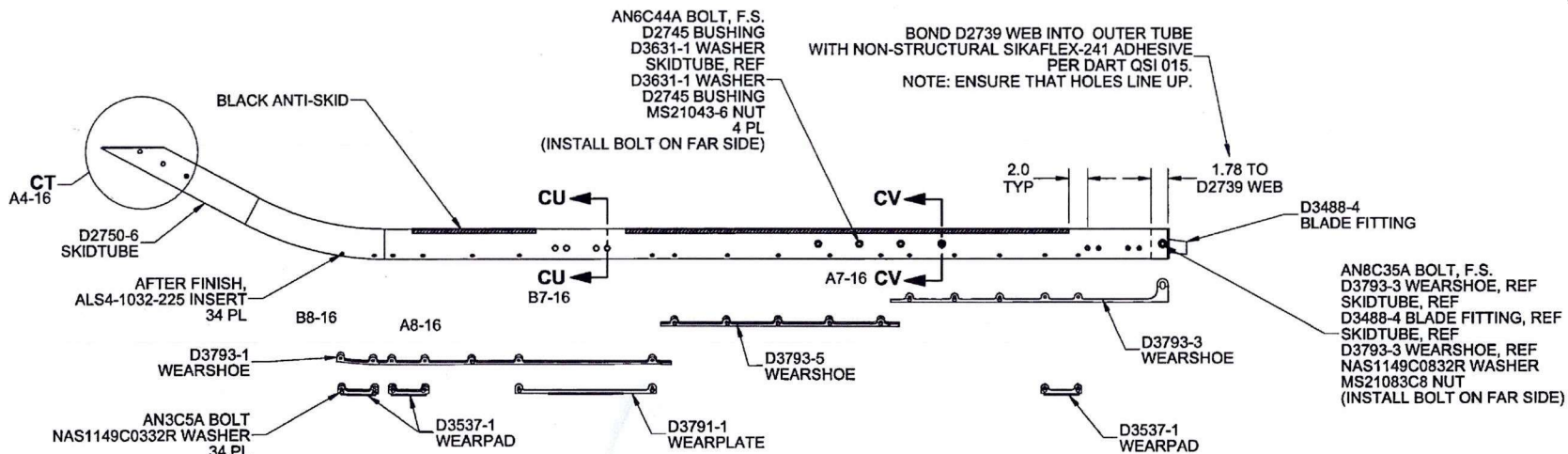
RELEASED
2018 OCT 19

APPROVED	DESIGN	MM	DART AEROSPACE USA, INC. EUGENE, OR	
	DRAWN	ZF		
	CHECKED	MW	DRAWING NO.	REV. H
	MFG. APPR.	DD	D2750	SHEET 11 OF 16
	APPROVED	NO	TITLE	SCALE
	DE APPR.	DS	350 SKIDTUBE ASSEMBLY	NTS
	DATE	18.03.05	COPYRIGHT © 1995 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	





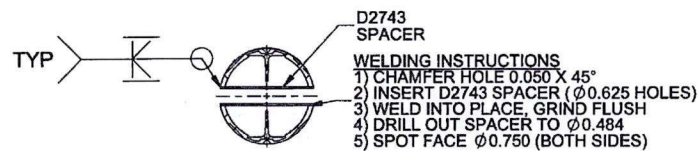




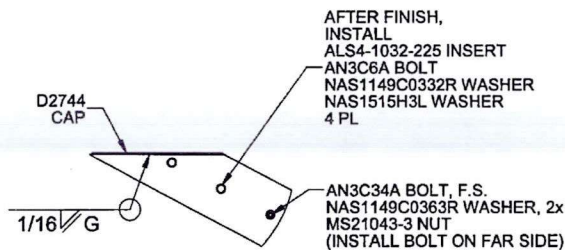
D2750-052 350 SKIDTUBE ASSEMBLY, RH



SECTION CU-CU SCALE 3X, 4 PL



SECTION CV-CV SCALE 3X, 4 PL (HARDWARE REMOVED FOR CLARITY)



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2018 OCT 19

DESIGN	MM	DART AEROSPACE USA, INC.	
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CHECKED	MW	DRAWING NO.	REV. H
MFG. APPR.	DD	D2750	SHEET 16 OF 16
APPROVED	NO	TITLE	SCALE
DE APPR.	DS	350 SKIDTUBE ASSEMBLY	NTS
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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



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Hawkesbury, ON K6A 1K7
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www.dartaerospace.com

Container No: S183812



Part: D350-636-011

Job No: 194935

Serial No/Batch: S183812

Revision: H

Inspector:

Exp Date:

Instructions: FAA STC SR00646SE 18/10/17 TC STC SH99 -

S183812 x1 xLH

5.0 PARTS LIST

D350-636-011/-012/-013/-014 SKIDTUBES AT CHG 008 AND SUBSEQUENT
D350-636-021/-022 SKIDTUBES AT CHG 001 AND SUBSEQUENT

Item	Qty -011	Qty -012	Qty -013	Qty -014	Qty -021	Qty -022	Qty -049	Part Number	Description
	X							D350-636-011	SKIDTUBE INSTALLATION, LH, AERAZUR/DART CYLINDRICAL FLOAT COMPATIBLE
		X						D350-636-012	SKIDTUBE INSTALLATION, RH, AERAZUR/DART CYLINDRICAL FLOAT COMPATIBLE
			X					D350-636-013	SKIDTUBE INSTALLATION, LH AIRCRAUSER/DART TRI-BAG FLOAT COMPATIBLE
				X				D350-636-014	SKIDTUBE INSTALLATION, RH AIRCRAUSER/DART TRI-BAG FLOAT COMPATIBLE
					X			D350-636-021	SKIDTUBE INSTALLATION, LH, STD
						X		D350-636-022	SKIDTUBE INSTALLATION, RH, STD
							X	D350-636-049	WEARSHOE KIT
1	1							D2750-041	SKIDTUBE ASSEMBLY, LH
1		1						D2750-042	SKIDTUBE ASSEMBLY, RH
1			1					D2750-043	SKIDTUBE ASSEMBLY, LH
1				1				D2750-044	SKIDTUBE ASSEMBLY, RH
1					1			D2750-051	SKIDTUBE ASSEMBLY, LH
1						1		D2750-052	SKIDTUBE ASSEMBLY, RH
*1	1							D2750-1	SKIDTUBE WELDMENT, LH
*1		1						D2750-2	SKIDTUBE WELDMENT, RH
*1			1					D2750-3	SKIDTUBE WELDMENT, LH
*1				1				D2750-4	SKIDTUBE WELDMENT, RH
1					1			D2750-5	SKIDTUBE WELDMENT, LH
1						1		D2750-6	SKIDTUBE WELDMENT, RH
**2	8	8	8	8	8	8		350A41-1027-20	SCREW
**3	8	8	8	8	8	8		23119AG120LE	WASHER
**4	8	8	8	8	8	8		22541N120	NUT
*5	1	1	1	1	1	1		AN8C35A	BOLT
*6A	1	1	1	1	1	1		NAS1149C0832R	WASHER
*7	1	1	1	1	1	1		MS21083C8	NUT
8	1		1		1			D3488-3	BLADE FITTING, LH
8		1		1		1		D3488-4	BLADE FITTING, RH
9	1	1	1	1	1	1		D2741	BLADE
10	2	2	2	2	2	2		AN8C21A	BOLT
11	2	2	2	2	2	2		NAS1149DO863J	WASHER
11C							8	D3672-1	WASHER
12	2	2	2	2	2	2		MS21083C8	NUT
*14	4	4	4	4	4	4		AN6C44A	BOLT
*15	8	8	8	8	8	8		D2745	BUSHING
*16	4	4	4	4	4	4		MS21043-6	NUT
*17	8	8	8	8	8	8		D3631-1	WASHER
*18	4	4	4	4	4	4		ALS4-1032-225	INSERT
*19	4	4	4	4	4	4		AN3C6A	BOLT
*20A	4	4	4	4	4	4		NAS1149C0332R	WASHER
*20B	4	4	4	4	4	4		NAS1515H3L	WASHER
*22	3	3	3	3	3	3	3	D3537-1	WEARPAD

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Revision: K

Date: 18.04.04

Item	Qty -011	Qty -012	Qty -013	Qty -014	Qty -021	Qty -022	Qty -049	Part Number	Description
*22A	1	1	1	1	1	1	1	D3791-1	WEARPLATE
*23A	1	1	1	1	1	1	1	D3793-1	WEARSHOE (REPLACES D3535-13)
*24A	1	1	1	1	1	1	1	D3793-5	WEARSHOE (REPLACES D3535-25)
*25A	1	1	1	1	1	1	1	D3793-3	WEARSHOE (REPLACES D3535-35)
*26A	34	34	34	34	34	34	34	AN3C5A	BOLT
*27	34	34	34	34	34	34	34	NAS1149C0332R	WASHER
*28	34	34	34	34	34	34	34	ALS4-1032-225	INSERT
*30	8	8	8	8				D3492-041	PLUG ASSEMBLY
*31	8	8						D3492-043	PLUG ASSEMBLY
*32			8	8				D3492-045	PLUG ASSEMBLY
***43	2	2	2	2				D3493-1	WASHER
50	2	2						D3532-1	SPACER
****97					1	1		AN3C34A	BOLT
****98					2	2		NAS1149C0363R	WASHER
****99					1	1		MS21043-3	NUT
100A							4	AN526C1032R10	SCREW
100B							4	AN526C1032R18	SCREW

* PART OF D2750-041/-042, D2750-043/-044 OR D2750-051/-052 ASSEMBLY

** TO BE SUPPLIED BY CUSTOMER

*** ONLY INSTALLED IF INSTALLING A DART FLOAT SYSTEM

***** PART OF D2750-051 OR D2750-052 ASSEMBLY

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